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## 3rd CIRP Conference on Surface Integrity (CIRP CSI)

Effects of tool geometry and process parameters  
on delamination in CFRP drilling: An overviewRuslan Melentiev<sup>a</sup>, Paolo C. Priarone<sup>b,\*</sup>, Matteo Robiglio<sup>b</sup>, Luca Settineri<sup>b</sup><sup>a</sup> Odessa National Polytechnic University, Shevchenko Avenue 1, 65044 Odessa, Ukraine<sup>b</sup> Politecnico di Torino, Department of Management and Production Engineering, Corso Duca degli Abruzzi 24, 10129 Torino, Italy\* Corresponding author. Tel.: +39 011 0907206; fax: +39 011 0907299. E-mail address: [paoloclaudio.priarone@polito.it](mailto:paoloclaudio.priarone@polito.it)**Abstract**

Fiber reinforced polymers (FRPs) show advantageous physical-mechanical, thermal, and dielectric characteristics, making them promising candidates for weight reduction in structural applications. However, machinability is often difficult because of the specificity of their structure. This paper highlights the latest advances in CFRP drilling. Key papers are analyzed with respect to workpiece materials, geometrical tool features, and input variables (such as variation in process parameters). The influence of tool geometry and process parameters on workpiece delamination and hole quality/integrity represents the primary focus of this review. In addition, some new data are presented and discussed.

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**Keywords:** Carbon fiber reinforced plastics; Drilling; Tool geometry; Delamination; Surface integrity.**1. Introduction**

Fiber reinforced polymers (FRPs) are increasingly applied in aerospace and automotive structural components, mainly due to their high strength-to-weight ratio and stiffness. FRPs are made of a thermoset or thermoplastic polymer matrix that binds carbon (CFRP) or glass (GFRP) fibers [1]. The machinability of such composite materials is related to the anisotropy/heterogeneity of their structure, together with the high abrasiveness caused by the fiber reinforcements [2-4]. Drilling is a common machining process for components made of composite laminates. The hole quality is affected negatively by matrix cratering, thermal damage, spalling, surface delamination, and material degradation (e.g., fiber pullout). Delamination, in particular, is defined as the interlaminar crack propagation in laminated fiber reinforced plies [3]. This phenomenon is due to the combined action of thrust force and torque. The presence of delamination significantly reduces the fatigue resistance as well as the hole quality in terms of dimensional and geometrical tolerances [5]. The design of drilling processes through the choice of suitable tools, process parameters, and cutting conditions appears to be a key task for

reducing the hole delamination. In this context, focusing on CFRP drilling, the present paper reviews and discusses the main outcomes achieved with different cutting tool geometries at the varying of process parameters. In addition, some new results obtained by the authors are included in the discussion.

**2. Drilling-induced delamination**

The delamination factor ( $F_d$ ) is the most commonly applied index for evaluating the delamination of a drilled hole.  $F_d$  is typically defined as the ratio between the maximum diameter of the delaminated zone ( $D_{max}$ ) and the hole nominal diameter ( $d$ ), as shown in Figure 1. The delamination factor can be assessed either at the hole entrance (where fibers are peeled up), or at the hole exit (where fibers are pushed down). At the hole entrance, adjacent plies could be separated by a peeling force due to the slope of the drill bit flutes. At the hole exit, the uncut plies below the drill could be affected by deformation owing to their reduced thickness. Push-out delamination is observed more frequently than peel-up delamination, particularly when the thrust force exerted by the drill is greater than the inter-ply bonding strength [1].

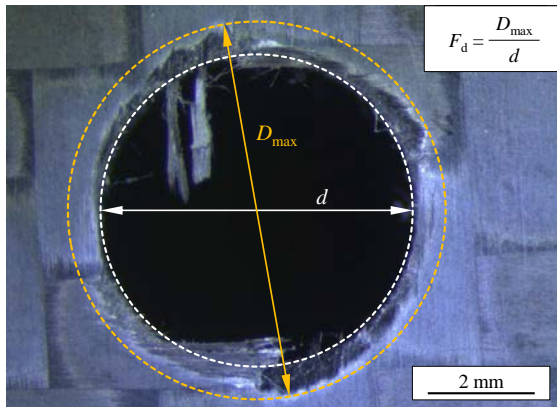


Fig. 1. Assessment of delamination factor ( $F_d$ ) at hole exit.

### 3. Effects of tool geometry on hole delamination

Many authors have focused on the drilling of composite materials with a variety of tool geometries. Besides standard twist drills [2-21], twist drills with double point angle [18], 'one shot' drills [13, 18], 'brad & spur' (or candle stick) drills [2, 4, 6-9, 12, 14, 17, 20, 22], drills with multiple flutes [3, 12, 13, 20], step drills [6, 8, 9, 14, 15, 17, 21], dagger drills [8, 14, 17], saw drills [4, 6, 7, 9], core drills [6, 9-11, 16], step-core [23-25] and core-special drills [6, 25] were also applied. The main difference among drill geometries is the different distribution of cutting forces exchanged with the workpiece.

#### 3.1. Conventional twist drills

The comparison conducted by Faraz et al. [13] between conventional twist drills, two types of three-flute drills with a helix angle, and straight-four-flute drills revealed that the conventional drill type led to a lower delamination (up to 50% with respect to the  $F_d$  of straight-four-flute drills), especially at the hole exit. This can be traced back to the lower thrust force level, especially compared to that of four-flute drills with a zero rake angle at the cutting edge. The authors highlighted that delamination, especially at the hole exit, was very sensitive to the rake angle of the drill cutting edge. Davim and Reis [3] showed that carbide twist drills achieved better performance than High Speed Steel (HSS) twist drills and carbide four-flute drills, allowing a lower delamination factor. In addition, carbide drills were a better choice for CFRP drilling also due to their lower tool wear progression. When using a pilot hole, drilling with twist drills represented the best solution as evaluated by Marques et al. [14] during the comparison of twist, brad, dagger, and special step drills. When drilling reinforced laminates it is preferable to use a drill bit geometry that reduces the indentation effect of the chisel edge. Entry delamination factor was found by Shyha et al. [15] to be (5%) lower with conventional drills compared to stepped drills. This result was in contrast with the results presented by the same authors in terms of thrust force, tool life, and drilling torque. To minimise delamination Durão et al. [17] suggested twist drills with a higher point angle ( $120^\circ$  instead of  $85^\circ$ ) with respect to brad drills, dagger drills, or

step drills. It is known that peel-up and push-down delamination are affected in contrasting ways by the point angle. Gaitonde et al. [5] highlighted that thrust force and delamination at the hole exit were reduced up to 45% by using a lower point angle ( $85^\circ$ ) that enables a cutting edge angle reduction. Regarding entry delamination, Shyha et al. [15] achieved better performance with the point angle of  $140^\circ$  with respect to the point angle of  $118^\circ$ . Within the same study, this result was in contrast to that in term of thrust force where the smaller point angle led to a lower force level.

#### 3.2. Other tool geometries

Compared to twist drills, 'brad & spur' drills reduce the delamination factor [2, 4, 7, 8, 12, 20], even if power and specific cutting pressure are higher [2]. Moreover, the thrust force depends on the chisel edge geometry: a shorter chisel edge length can imply a lower contribution on thrust force. Candle stick drills and saw drills have a smaller center with respect to twist drills. This entails a smaller extent of the last laminate that is subjected to bending force. It has been found that delamination occurs only over a critical thrust force level. Above that level, delamination is due to matrix cracks generated by the growth of crack tips [4]. Tsao and Hocheng [7] highlighted a lower delamination extent (of 55%) when drilling with candle stick drills rather than with twist or saw drills. Candle stick drills (C-shape) used by Durão et al. [8] achieved the best results in terms of delamination compared to twist drills (either with or without the pilot hole), dagger drills, and step drills. During drilling of GFRP laminates Abrão et al. [12] found lower damage on both sides of the holes when using 'brad & spur' drills with respect to two different twist drills (made of HSS or tungsten carbide) and three-flute drills. This was also due to the lower thrust force values allowed by this type of geometry that is similar to a trepanning tool. Spur drills used by Grilo et al. [20] performed holes with no or only slight delamination (below 1.3 for the lowest feed rate) for all cutting conditions tested, either at the hole entrance or at the hole exit. Twist drills and four-flute drills gave worse results with respect to spur drills.

According to Hocheng and Tsao [9] core drills showed better results in terms of delamination compared to those of twist drills, saw drills, candle stick drills, and step drills. Core drills were advantageous because they allowed a higher critical thrust force level, which causes the onset of delamination. Core drills caused a lower delamination in comparison to twist drills due to the distribution of the thrust force toward the drill periphery [10]. Tsao [11] showed that the surface of holes drilled with core drills was smoother than that obtained with twist drills. It was shown that cemented or plated diamond core drills are suitable to improve hole quality compared to conventional drills [16]. Plated diamond core drills show better self-dressing capability and more chip pockets than cemented diamond core drills. In addition, plated diamond core drills are not easily clogged or smeared out.

Step drills with optimized geometry were developed by Isbilir and Ghassemieh [21] using a 3D FE model minimizing delamination and other hole defects. FE simulations indicated that step drills presented advantages in comparison to twist

drills, also in terms of thrust force and torque reduction, and workpiece stress distribution. Step-core drills with different inside drill geometries were analyzed by Tsao [23]. The saw type of the inside drill was found the best choice to reduce delamination. However, conventional twist drills still represent an industrial standard, due to some limitations imposed by alternative tool geometries [24]. For instance, the chip removal clog might be a critical issue when using core drills [25]. Moreover, trepanning tools or core tools are not suitable to drill small holes [16].

#### 4. Effects of process parameters on hole delamination

The influence of process parameters (e.g., feed rate and cutting speed) on hole delamination has been investigated by many authors. Results are somehow debated, particularly when the effect of cutting speed is concerned, as shown in Table 1. It has been widely recognized that process parameters play a significant role on thrust force magnitude and, as a result, on delamination. The correlation among these output variables has been established in [7, 9, 13]. It is worth to remark that drilling of composite laminates with standard tools is usually performed in dry conditions, except some rare cases in which high pressure water cooling was applied [21]. On the contrary, when using core drills, water (or air) supplied at high pressure is applied to remove chips, to cool the tool, and to prevent burns on the workpiece [9, 16].

Table 1. Influence of process parameters on delamination.

Process parameter variation	Effect on delamination	References	
		Peel-up delamination	Push-down delamination
Cutting speed increase	Increase	[2]	[2, 3, 19]
	No/slight effect	[12, 15]	[12, 14]
	Decrease	[22]	[16, 22, 23]
Feed increase	Increase	[2, 5, 12, 14, 15, 19, 20]	[2, 3, 15, 17, 19, 20, 22, 23]

##### 4.1. Feed rate

The increase in feed rate usually leads to the increase in hole delamination, according to [1-3, 5, 12, 14, 15, 17, 19, 20, 23]. When drilling CFRP composites, feed rate was proved to be the cutting parameter that has the highest influence [2]. A relationship between feed rate and delamination factor was highlighted also when using different tool geometries [12] at different cutting speeds [2, 3]. The feed increase may result in a sort of punching operation instead of a pure cutting process. For high-speed drilling of CFRP, the choice of low feed rates was found to be essential for minimizing delamination at the hole entrance. Gaitonde et al. [5] developed a second order non-linear mathematical model to predict the delamination factor as a function of feed rate, cutting speed, and point angle. The results proved that hole damage increased as a consequence of the increase in thrust force (due to the increase of feed rate). In addition, the influence of feed rate on thrust force, push-out delamination, and hole diameter when high-

speed drilling was confirmed by [19]: lower feed rates (0.01 mm/rev) reduced the thrust force and the push-out delamination. Moreover, feed rate has a significant influence on drilling-induced delamination also when using step-core drills with various diameter ratios. For that kind of tools, the minimum value of feed rate (8 mm/min) was suggested by Tsao [23]. No delamination on both sides of holes was found when using spur drills within a wide range of feed rates up to 2025 mm/min. For a feed rate of 3000 mm/min, such drill geometry only produced a slight delamination at the hole entrance [20]. A low feed rate can increase the heating of the surrounding matrix material and, in some cases, it can cause a matrix softening [14] or thermal degradation [17]. As far as tool wear is concerned, it is worth to remark that an intermediate value of feed should be selected, since the increase in feed rate leads to a reduced contact time between cutting tool and workpiece material. As a consequence, the abrasive action and the cutting temperatures are limited [15].

##### 4.2. Cutting speed

Controversial effects of cutting speed on delamination were noticed in literature. Peel-up delamination was proved to increase [2], decrease [22], or show an unclear trend [12, 15] when increasing the cutting speed. Similarly, push-down delamination was observed to increase [2, 3, 19], decrease [16, 22, 23], or remain fairly unchanged [12, 14].

Davim and Reis [2, 3] evidenced that cutting speed has a significant influence on delamination at hole exit when drilling CFRP by using 'brad & spur' drills, carbide or HSS twist drills, and four-flutes drills. For all the step-core drills tested in [23, 24], the highest cutting speed allowed reaching the lowest delamination values at both sides of the drilled holes. High-speed drilling (100-600 m/min) was noted to be a viable solution to reduce the damage at hole entrance [5]. A critical cutting speed value (i.e. the optimum speed value allowing the minimum thrust force level and, consequently, the minimum delamination) was also identified by Marques et al [14]. Results from Krishnaraj et al. [19] revealed that peel-up delamination was not influenced by spindle speed variation, while push-out delamination was increased when drilling at higher spindle speed. In that case, the heating of the matrix resulted in lower workpiece stiffness, therefore delamination was supposed to begin at lower force levels. Vice versa, in the study of Lazar and Xirouchakis [18] spindle speed variation had a limited influence on the cutting load distribution and, therefore, on delamination. Peel-up and push-down delamination observed by Palanikumar [22] during GFRP drilling was reduced when increasing spindle speed, and this evidence was according to thrust force values that showed the same trend.

##### 4.3. Experimental tests

Influence of cutting speed and feed on delamination was investigated by the authors when drilling a 4-mm CFRP laminate by using TiAlN-coated carbide twist drills and diamond core drills. For diamond drilling feed was 0.02 and 0.06 mm/rev, and cutting speed was 30 and 40 m/min. For

conventional drilling feed was 0.02, 0.06, and 0.12 mm/rev, and cutting speed was 30, 40, and 50 m/min. The experiments were executed three times with new tools, and the delamination factor was calculated either at hole entry or at hole exit. The graphs in Figure 2 present the average values of  $F_d$  as a function of feed and cutting speed. The dispersion of the results generally led to standard deviations at most of 9% of the average values. By using twist drills, push-down delamination (at hole exit) increased for higher feed rates. The tests confirmed the significant influence of feed on delamination. On the contrary, for both the drill geometries, cutting speed showed no significant influence on delamination on both sides of the holes. Delamination at the hole exit induced by core drills was higher than that of twist drills, while delamination at hole entry was comparable. This fact is in contrast with results reported in literature, but it is justified by higher thrust force values measured when using core drills.

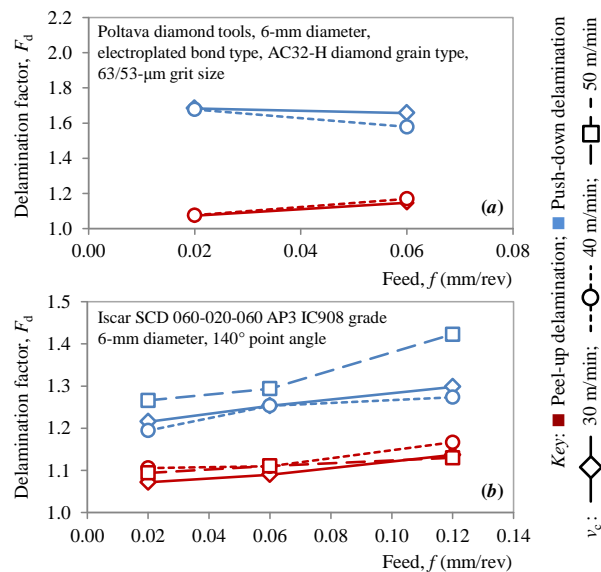


Fig. 2. Influence of process parameters on peel-up and push-down delamination using core drills (a) and twist drills (b).

## 5. Conclusions and outlooks

When drilling CFRPs, the influence of process parameters and tool geometry on delamination and hole quality are the key aspects that have been investigated over the years. This paper presents a brief overview of the key results recently presented in literature. Feed rate was found to have the strongest influence on delamination, therefore a low value of this parameter is recommended. Cutting speed can lead to various effects on delamination, which depend on the specific range of variation considered and on the tool geometry used. Furthermore, drilling performance may be influenced by the type of workpiece material and tool material/coating. New results have been proposed and discussed comparing the performance of two drill geometries. Overall, when drilling CFRP using a standard twist drill, a low feed rate together with a high cutting speed can reduce the risk of delamination.

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